

Work Order ID 68731

Wednesday, April 20, 2011 11:15:44 AM



Page 1

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3021

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: M10A226

EL 11-4-28

[Signature]

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 DE 11/05/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68731

Wednesday, April 20, 2011 11:15:45 AM



Page 2

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. Wloslor

100

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 115128

Memo

0.00

Powder Coating

START TIME: 1:00
OVEN TEMPERATURE: 300°
FINISH TIME: 1:30

1 11-5-2

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 p. M. Wloslor

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 68731


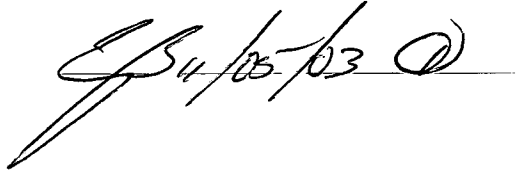

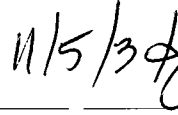

Page 3

Wednesday, April 20, 2011 11:15:45 AM

Item ID: D3021-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Tube Assembly
Start Date: 4/20/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/25/2011 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo <u>w/o 68622</u>	0.00 0.00							<u>EP 4/25/11</u> 
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/5/3</u>  <u>PL 11-05-3</u> 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 11:15:51 AM

Page 1

Work Order ID: 68731

Parent Item: D3021-041

Parent Item Name: Tube Assembly

Start Date: 4/20/2011


Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11		Manufactured	No			100	Each	12.0000	2	2			
													
cap													

Location Loc Qty Loc Code

WA049 12
52583 12

M4130NT0.750W.049		Purchased	No			100	f	85.2300	2.0833	2.192947			
													
4130 RD Tube .750 x.049W													

Location Loc Qty Loc Code

MAT033 85.23
10133 10.73
110740 74.5

11-4-28

2

11-4-28

2.08

W/O:		WORK ORDER CHANGES						
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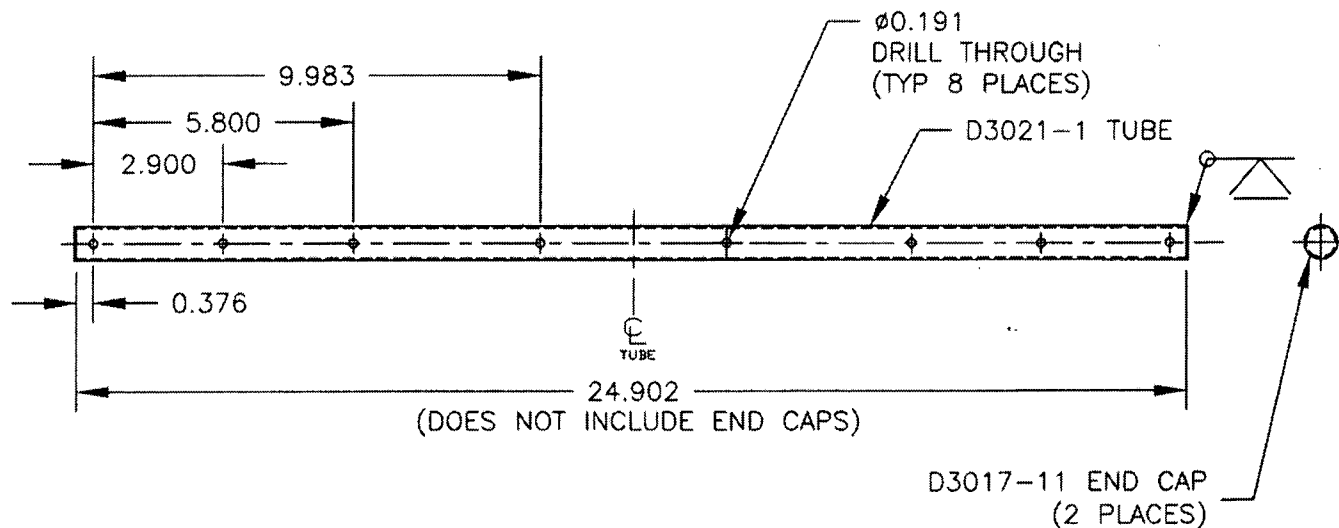
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOW COPY
REI
ENGINE
UNCONTROLLED
SUBJECT TO
WITHO
WORK ORDER
NO. 48731
P1104-20



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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